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DART AEROSPACE LTD.	Work Order:	21017
Description: Saddle Fitting, Fwd (Outboard/Inboard)	Part Number:	D2571/D2572
Drawing: D2571 Rev. D/D2572 Rev. D	Qty:	20
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	EP	04.06.08	20
2	MV	Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: B20724	EP	04/06/08	20
3	MV	Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: B20723	EP	04/06/08	20
4	MV	Fixturing W/O No. n/A Fixturing Inspection last completed added by EP	EP	04/06/08	20
5	MV	Program Batch No. B21017 Double check by: FE	EP	04/06/08	20
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	EP	04/07/06	20
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	EP	04/07/06	20
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	EP	04/07/06	20
9	MV	Machine keyway as per dwg D2571 & D2572	EP	04/07/06	20
10	MV	Deburr and remove all machining marks	EP	04/07/06	20
11	MV	Tumble for 20 minutes	EP	04/07/06	20
12	QC1	Inspect all dimensions to dimension sheets	EP	04/07/06	20
13	QC7	Second inspection	EP	04/07/07	20
14	FP	Acid etch and alodine as per QSI 005 4.1	EP	04/07/07	20
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	EP	04/07/09	20
16	QC3	Inspect Powder Coat	EP	04/07/09	20
17	ST	Identify and Stock.	EP	04/07/09	20
18	AC	Cost / Part 92.61 70.32	S4C	04-07-12	20
19	DC	Close W/O 95.84 72.43 Inspection Level 21	EP	04.07.13	20

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
I	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	

RELEASED  
02/10/15 RF